

NCL-19-7526



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3912-1

Job Sheet 190200



Part No: D3912-1

Job Qty: 3 pcs

Part Name: Eyebolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 2/15/19

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV B IPP RevA: New Issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	3 pcs	2/15/19	2/15/19	0.00	2.14	Doosan - 1		<i>[Signature]</i>
110	QC 2	3 pcs	2/15/19	2/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		<i>[Signature]</i>
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



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CANADA
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Container No: S151045



Part: D3912-1

Job No: 190200

Serial No/Batch: S151045

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/05/19

cote 1.100 T/- 10/0
(1.088)

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2/5/2019

[Dart Hawkesbury] Job Sheet - Leroux, Jason

120 QC 8	3 pcs	2/15/19	0.00 0.00	QC 2 - 66	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mm 19/02/19
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
130 Packaging 3-1 - Stock - B4B	3 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	STOS 6 FEB 26 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140 QC 21 - SA	3 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	FEB 26 2019

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QC 21 - SA - 53

Part Op 100 - (Doosan Lathe) TURN AS PER FOLIO FA871AND DWG Prog Rev: _____ Debur as required
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	.8400 ft (-28 ea)	100-Doosan - 1	6/180/0

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	1	16	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100		
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690		
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490		
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870		
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100		
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5		
7	Eyebolt	0.220Inches ± 0.030	0.250 0.190		
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720		
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960		
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690		
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170		
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150		
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200		
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius	
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	Radius	
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615		
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640		
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090		
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410		
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius	
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970		
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220		
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850		
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080		
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719		

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Entered: 22 Date: Oct 24/19



NCR No. 19-7526

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>190200</u> Part No. <u>D3912-1</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date: <u>19/2/7</u>		Sequence #:			QTY Affected:				MRB (QSI042)																																
Description Work Order Deviation					Disposition					INSP 12 GP 19/2/7																															
Dimension 1.100 is up to 0.002 under tolerance.					Acceptable. Section not critical in strength. Sufficient clearance with D3801-1 Spring Plug-Plunger, will assemble & function correctly.					Completed By																															
										GP 19/2/7																															
										Lead hand / Supervisor																															
19/02/07			QC / QA Coordinator			DAS 55 9-89 19/02/07																																			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐					FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☒ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>									☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☒ Fit/Function	☐ Off-set/Set-up	
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